



Date: Thursday, 16/11/2006 9:45:29 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STIFFENER
Job Number : 29145	
Estimate Number : 10481	
P.O. Number : N/A	Part Number : D2353
This Issue : 16/11/2006 S.O. No. : N/A	Drawing Number : D2353 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 29145	Material : N/A
Written By : 	Due Date : 23/11/2006 Qty: 4 Um: Each
Checked & Approved By : 	
Comment : Est Rev: A Removed from 9 Digit 05-11-10 EC Est: B 06.11.15 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1536 sf(s)/Unit Total : 0.6145 sf(s)
 Material: 2024-T3 .050 sheet
 Aluminum (QQ-A-250/5)
 Batch: H19053

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2353
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

SAD 06:12:28 (4)
 SAB 06:17:28 (4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:12:28 (4)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

207-01-02 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 29 Date: 7/11/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/11/2006 9:45:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STIFFENER

Job Number: 29145

Part Number: D2353

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2353

SB

07/01/10 (4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/10 (4)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.R. / J.L.

07/01/11

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

2100780

R. / J.L.

07/01/16

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/17 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57171

07/01/17 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/17 (4)

Job Completion



C 07/01/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

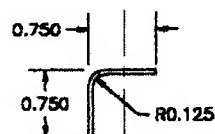
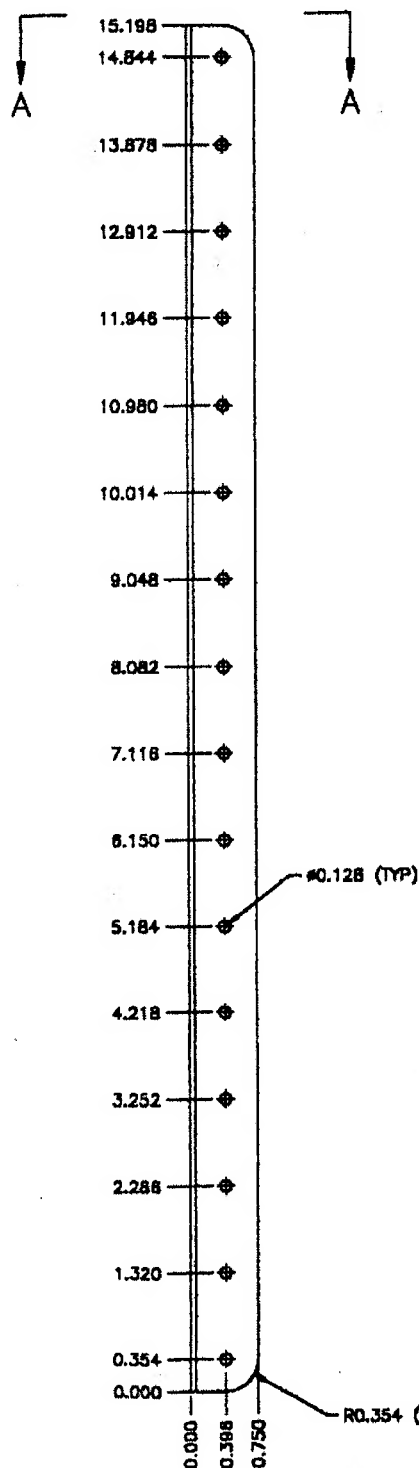
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED QA	D2353	SHEET 1 OF 1
DATE	TITLE		SCALE
95:02:10	STIFFENER		1:2
B	95:02:23	ADD TEXT	



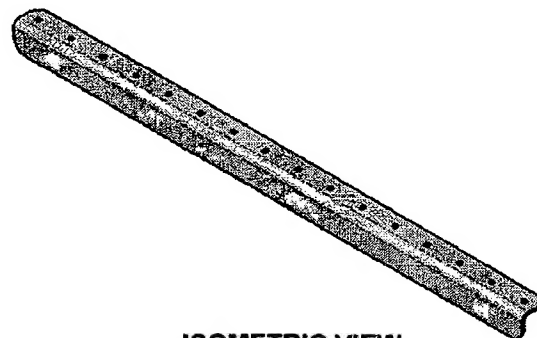
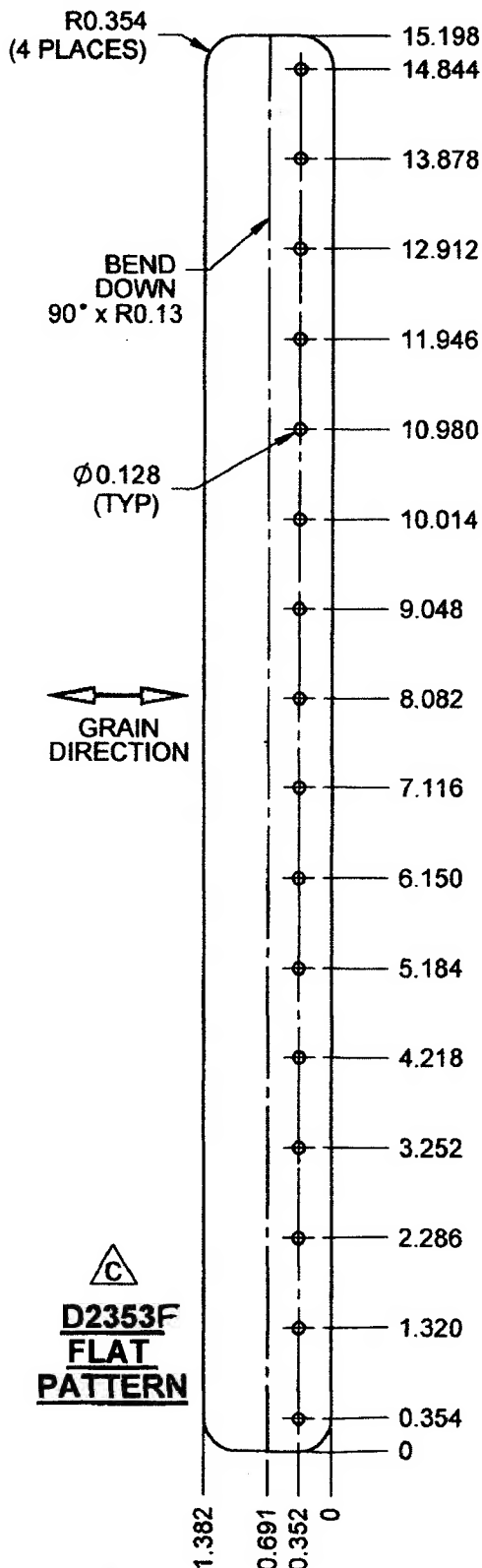
SECTION A-A

MATERIAL 2024-T3 0.050 THICK
QQ-A-250/5
FINISH: POWDER COAT CRINKLE BLACK

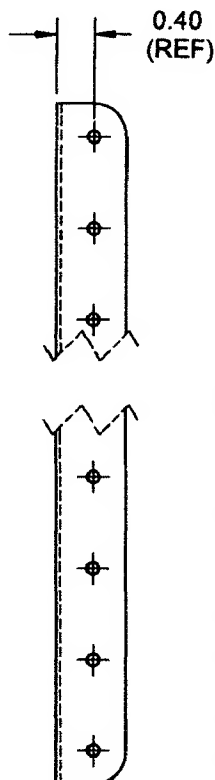
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29145



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13	TITLE STIFFENER SCALE 1:2		
REV	DATE	DESCRIPTION	
B	95.02.23	ADD TEXT	
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG	



ISOMETRIC VIEW
SCALE 1:4



D2353
BEND DETAIL

- NOTES:
- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK
PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T4S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE FINE POINT PERMANENT INK MARKER
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

RELEASED
06 11-28 [Signature]

COPYRIGHT © 1995 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.